



INSTRUCTIONS FOR COMPLETING DD FORM 1423

(See DoD 5010.12M for detailed instructions.)

FOR GOVERNMENT PERSONNEL

- Item A. Self-explanatory.
- Item B. Self-explanatory.
- Item C. Mark (X) appropriate category: TDP - Technical Data Package; TM - Technical Manual; Other - other category of data, such as 'Provisioning', 'Configuration Management', etc.
- Item D. Enter name of system/item being acquired that data will
- Item E. Self-explanatory (to be filled in after contract award).
- Item F. Self-explanatory (to be filled in after contract award).
- Item G. Signature of preparer.
- Item H. Date CDRL was prepared.
- Item I. Signature of CDRL approval authority.
- Item J. Date CDRL was approved.
- Item 1. See DoD FAR Supplement Subpart 4.71 for proper numbering.
- Item 2. Enter title as it appears on data acquisition document cited in Item 4.
- Item 3. Enter subtitle of data item for further definition of data item (optional entry).
- Item 4. Enter Data Item Description (DID) number, military specification number, or military standard number listed in DoD 5010.12-L (AMSDL), or one-time DID number, that defines data content and format requirements.
- Item 5. Enter reference to tasking in contract that generates requirement for the data item (e.g. Statement of Work paragraph number).
- Item 6. Enter technical office responsible for ensuring adequacy of the data item.
- Item 7. Specify requirement for inspection/acceptance of the data item by the Government.
- Item 8. Specify requirement for approval of a draft before preparation of the final data item.
- Item 9. For technical data, specify requirement for contractor to mark the appropriate distribution statement on the data (ref DoDD 5230.24).
- Item 10. Specify number of times data items are to be delivered.
- Item 11. Specify as-of date of data item, when applicable.
- Item 12. Specify when first submittal is required.
- Item 13. Specify when subsequent submittals are required, when applicable.
- Item 14. Enter addresses and number of draft/final copies to be delivered to each addressee. Explain reproducible copies in Item 16.
- Item 15. Enter total number of draft/final copies to be delivered.
- Item 16. Use for additional/clarifying information for items 1 through 15. Examples are: Tailoring of documents cited in Item 4; Clarification of submittal dates in Items 12 and 13; Explanation of reproducible copies in Item 14; Desired medium for delivery of the data item.

FOR THE CONTRACTOR

- Item 17. Specify appropriate price group from one of the following groups of effort in developing estimated prices for each data item listed on the DD Form 1423.
  - a. Group I. Definition - Data which is not otherwise essential to the contractor's performance of the primary contracted effort (production, development, testing and administration) but which is required by DD Form 1423.
 

Estimated Price - Costs to be included under Group I are those applicable to preparing and assembling the data item in conformance with Government requirements, and the administration and other expenses related to reproducing and delivering such data items to the Government.
  - b. Group II. Definition - Data which is essential to the performance of the primary contracted effort but the contractor is required to perform additional work to conform to Government requirements with regard to depth of content, format, frequency of submittal, preparation, control, or quality of the data item.
 

Estimated Price - Costs to be included under Group II are those incurred over and above the cost of the essential data item without conforming to Government requirements, and the administrative and other expenses related to reproducing and delivering such data item to the Government.
  - c. Group III. Definition - Data which the contractor must develop for his internal use in performance of the primary contracted effort and does not require any substantial change to conform to Government requirements with regard to depth of content, format, frequency of submittal, preparation, control, and quality of the data item.
 

Estimated Price - Costs to be included under Group III are the administrative and other expenses related to reproducing and delivering such data item to the Government.
  - d. Group IV. Definition - Data which is developed by the contractor as part of his normal operating procedures and his effort in supplying these data to the Government is minimal.
 

Estimated Price - Group IV items should normally be shown on the DD Form 1423 at no cost.
- Item 18. For each data item, enter an amount equal to that portion of the total price which is estimated to be attributable to the production or development for the Government of that item of data. These estimated data prices shall be developed only from those costs which will be incurred as a direct result of the requirement to supply data, over and above those costs which would otherwise be incurred in performance of the contract if no data were required. The estimated data prices shall not include any amount for rights in data. The Government's right to use data shall be governed by the pertinent provisions of the contract.

# ENGINEERING DATA LIST

REVISION: 03

\* HISTORY \*

DATE : 28NOV01		DATA TECH : SCH		ORGN SYMBOL :		LGMPM		PR NR :		APPLICATION: KC-135R		PAGE 1 OF 2	
CAGE: 98747		MANUFACTURER NAME: OGDEN AIR LOGISTICS CENTER OGDEN				REFERENCE NR: 200210077-10		NOUN :		PISTON, LANDING GEAR		NSN : 16200115700201E	
CAGE	DRAWING NUMBER	REV	NR SHEETS	NR CARDS	FURN CODE	DIST CODE	NOUN	REQUIREMENTS					
82918 *	PL458-56035 (P)	/	0003	0000	S		PARTS LIST	ECO					
	/02C0589												
82918 *	PL458-56119 (P)	/ B	0005	0000	S		PARTS LIST	ECO					
	/02C0579												
82918 *	PL458-56149 (P)	/ B	0004	0000	S		PARTS LIST	ECO					
	/02C0581												
82918 *	PL458-56178 (P)	/ C	0004	0000	S		PARTS LIST	ECO					
	/98C0173												
	/02C0583												
82918 *	PL458-56179 (P)	/ A	0001	0000	S		PARTS LIST	ECO					
	/02C0585												
81205 *	30-3110 (P)	/ C	0001	0000	S		BUSHING - EQUIL ATTACH, MLG	ECO					
	/02C0586												
82918 *	458-56002 (P)	/	0008	0000	S		FIN & MFG CONT RQMTS	ECO					
	/02C0587												
82918 *	458-56035 (P)	/	0001	0000	S		BUSHING - MLG	ECO					
	/02C0588												
82918 *	458-56119 (P)	/ B	0002	0000	S		CYL ASSY - INNER, FIN MACH MLG	ECO					
	/87C494							ECO					
	/88C158							ECO					
	/88C238							ECO					
	/98C0231							ECO					
	/98C0230							ECO					
	/02C0518							ECO					
	/02C0578							ECO					
82918 *	458-56149 (P)	/ B	0002	0000	S		INNER CYL - FORGING MLG	ECO					
	/02C0580												
82918 *	458-56178 (P)	/ C	0001	0000	S		BUSHING - INNER CYL PIVOT, MLG	ECO					
	/88C1278							ECO					
	/95C114							ECO					

GP L R

GP L R



REV:	<b>ENGINEERING DATA REQUIREMENTS</b> (ATTACHMENT "A")	
NOTE: MILITARY SPECIFICATIONS //STANDARDS WILL NOT BE FURNISHED IN THE BID SET		
1. THE FOLLOWING INSTRUCTIONS ARE FURNISHED FOR THE MANUFACTURE OF <b>CYLINDER ASSY - INNER, FINISH MACHINED - MAIN LANDING GEAR</b>		
2. PART NUMBER	3. NATIONAL STOCK NUMBER	
200210077-10	1620-01-157-0020LE	
4. THE FOLLOWING SPECIFICATIONS/STANDARDS, ETC., WILL BE USED IN LIEU OF THE DATA INDICATED. THE SUPERSEDED DATA WILL NOT BE FURNISHED UNLESS SO INDICATED.		
5. IDENTIFICATION AND MARKING PER MIL-STD-130 IN LIEU OF BAC 5307, D-18462.		
6. SERIAL NUMBER SHALL BE VIBROPEENED (WITH VIBRATING PNEUMATIC PENCIL), IN 0.09" LETTERS 0.004" - 0.007" DEEP IN THE LOCATION INDICATED. IF THE DRAWING DOES NOT INDICATE A LOCATION, OO-ALC/LILE SHALL PROVIDE S/N LOCATION INSTRUCTIONS. SERIALIZATION OF ITEM SHALL BE ACCOMPLISHED AS FOLLOWS: THE SERIALIZATION SHALL BEGIN WITH THE CAGE OF THE CONTRACTOR NAMED ON THE CONTRACT, FOLLOWED BY A DASH AND THE 2 DIGIT YEAR OF MANUFACTURE, FOLLOWED BY A DASH AND A SEQUENTIALLY UNIQUE 3 DIGIT NUMBER. A CONTRACTOR WHO RECEIVES NUMEROUS INTERMITTENT CONTRACTS SHALL START SERIALIZATION OF ITEM WITH THE NEXT NUMBER IN SEQUENCE OF THE PRIOR CONTRACT. IF A CONTRACT PRODUCES MORE THAN 999 ITEMS, THE SERIAL NUMBER SHOULD BEGIN USING 4 DIGIT SERIAL NUMBERS. THE SERIAL NUMBER SHOULD APPEAR LIKE THIS: "S/N 98747-00-001".		
7. HEAT TREAT TO DWG REQUIREMENTS PER SAE AMS-H-6875 IN LIEU OF BAC 5601 AND MIL-H-6875.		
8. APPLICATIONS OF SPECIAL PURPOSE COATINGS PER MIL-STD-7179 IN LIEU OF BAC 5710, TYPE 41 AND BAC 5736.		
9. USE 300M STEEL PER SAE AMS 6257, CLASS 2 IN LIEU OF 300M STEEL PER MIL-S-8844, CLASS 3.		
10. PERFORM MAGNETIC PARTICLE INSPECTION PER ASTM E 1444 IN LIEU OF BAC 5424. USE FULL WAVE DIRECT CURRENT (FWDC), WET CONTINUOUS METHOD, FLUORESCENT TYPE WITH THE FOLLOWING ACCEPTANCE/REJECTION CRITERIA: NO DEFECTS ALLOWED. THE INTENT OF NO DEFECTS ALLOWED IS THAT THE INSPECTION IS CONDUCTED AT THE REQUIRED SENSITIVITY LEVEL AND THERE SHALL BE NO INDICATIONS ALLOWED. THE INSPECTOR PERFORMING THE INSPECTION SHALL BE CERTIFIED TO LEVEL II WITH THE INSPECTION PROCEDURE DEVELOPED BY A LEVEL III AS SPECIFIED IN NAS-410.		
11. PERFORM FLUORESCENT PENETRANT INSPECTION PER ASTM E 1417, TYPE I, METHOD B OR C, LEVEL 3 OR 4 IN LIEU OF BAC 5423, WITH THE FOLLOWING ACCEPTANCE/REJECTION CRITERIA: NO DEFECTS ALLOWED. THE INTENT OF NO DEFECTS ALLOWED IS THAT THE INSPECTION IS CONDUCTED AT THE REQUIRED SENSITIVITY LEVEL AND THERE SHALL BE NO INDICATIONS ALLOWED. THE INSPECTOR PERFORMING THE INSPECTION SHALL BE CERTIFIED TO LEVEL II WITH THE INSPECTION PROCEDURE DEVELOPED BY A LEVEL III AS SPECIFIED IN NAS-410.		
12. ON PARTS HEAT TREATED 180 KSI AND ABOVE, ANY SURFACES GROUND/MACHINED AFTER HEAT TREAT WILL BE INSPECTED FOR ABUSIVE GRINDING/MACHINING BURNS PER MIL-STD-867. GRINDING WILL BE PER MIL-STD-866 IN LIEU OF BAC 5032.		
13. DECARBURIZATION ON ANY SURFACE SHALL NOT EXCEED .003 INCH UNLESS OTHERWISE NOTED.		
14. FINISH AND MANUFACTURING CONTROL REQUIREMENTS PER DWG 458-56002.		
PREPARED BY	SYMBOL	DATE
CAROL HYER	LGMPM	21 Aug 02

REV:	ENGINEERING DATA REQUIREMENTS CONTINUATION SHEET (ATTACHMENT "A")	
PART NUMBER 200210077-10	NATIONAL STOCK NUMBER 1620-01-167-0020LE	

15. SHOT PEEN ALL EXTERNAL AND INTERNAL SURFACES PER SAE AMS-S-13165 IN LIEU OF BAC 5730, USING HARD SHOT, R/C 55-65, SHOT RANGE .016 - .033, COVERAGE 2.0, INTENSITY .012A - .018A EXCEPT AS NOTED ON DRAWING.

16. INSTALL BUSHINGS PER THE FOLLOWING IN LIEU OF BAC5435:

A. THE BUSHING INSTALLATIONS SHALL BE ACCOMPLISHED IN SUCH A MANNER AS TO AVOID DAMAGE TO THE FINISH ON THE I.D. OF THE HOUSING INTO WHICH THE BUSHING IS INSTALLED, OR THE FINISH OF THE O.D. OF THE BUSHING. FORCED INSTALLATION OF SUB-ZERO INSTALLATIONS, SUCH AS THE USE OF A PRESS OR HAMMER IS NOT PERMITTED, AND IS NOT ACCEPTABLE. A SMALL NON-METALLIC HAMMER MAY BE USED TO TAP THE BUSHING INTO ALIGNMENT WITH THE HOUSING BORE, OR TO SEAT THE BUSHING.

B. PRIOR TO BUSHING INSTALLATION, THE PARTS AND HOUSING BORE SHALL BE CLEANED WITH A CLEANING SOLVENT TO REMOVE ALL CONTAMINATION.

C. LIQUID NITROGEN SHALL BE USED FOR ALL SUB-ZERO INSTALLATIONS UNLESS SOME OTHER SUB-ZERO COOLANT IS SPECIFIED, AND APPROVED BY OO-ALC/LILE ENGINEERING. THE SOAK TIME OF THE BUSHING IN THE LIQUID NITROGEN SHALL BE SUFFICIENT TO ALLOW THE BUSHING TO REACH THE SAME TEMPERATURE AS THE COOLANT.

D. THE BUSHING SHALL BE INSTALLED INTO THE HOUSING IMMEDIATELY UPON REMOVAL FROM THE COOLANT WITH AN ABSOLUTE MINIMUM OF LOST TIME. TRIAL RUNS SHALL BE ACCOMPLISHED AS NECESSARY TO MINIMIZE INSTALLATION TIME WHICH SHOULD BE IN THE ORDER OF ABOUT SEVEN (7) SECONDS MAXIMUM.

E. IT MAY OCCASIONALLY BE NECESSARY TO HEAT THE HOUSING INTO WHICH THE BUSHING IS TO BE INSTALLED, IN ADDITION TO SUB-ZERO COOLING OF THE BUSHING. DETAIL PARTS IN PROCESS WILL NOT HAVE PAINT OR SEALANT OR OTHER ORGANIC MATERIAL APPLIED PRIOR TO HEATING, THE PARTS SHALL BE HEATED BY THE USE OF RADIANT HEAT TECHNIQUES, SUCH AS THERMAL BLANKETS, INFRARED LAMPS ETC.; TO THE MAXIMUM TEMPERATURE OF 250 F. TEMPERATURE MEASURING DEVICES SHALL BE USED TO MONITOR HEAT AND SHALL BE LOCATED ON AREAS OF THE PART EXPECTED TO REACH MAXIMUM TEMPERATURE. NO SCALING, OXIDATION, OR CORROSION SHALL BE PERMITTED.

F. BUSHINGS WITHOUT FLANGES SHALL BE INSTALLED INTO HOUSING BORE WHICH HAS RECEIVED A LIGHT COAT OF SEALANT PER MIL-PRF-81733. INSTALL SHRUNKEN BUSHING AND WIPE OFF ANY EXCESS SEALANT THAT MAY HAVE EXTRUDED AROUND THE PERIPHERY OF BOTH ENDS OF THE BUSHINGS.

G. BUSHINGS WITH FLANGES SHALL BE INSTALLED IN A SIMILAR MANNER AS PARAGRAPH (F) EXCEPT SEALANT SHALL ALSO BE APPLIED TO FACE OF LUG UNDER FLANGE. SEALANT SHALL BE APPLIED IN SUCH A MANNER AS TO ENSURE COMPLETE COVERAGE OF INSIDE FACE OF BUSHING FLANGE WHEN BUSHING IS INSTALLED. WIPE OFF ANY EXCESS SEALANT AROUND PERIPHERY OF BUSHING FLANGE FORMING A BEAD. WIPE ANY EXCESS SEALANT FROM OTHER END OF BUSHING ALSO.

H. FOR BUSHINGS WITH EXTERNAL GREASE GROOVES THE INSIDE OF THE LUG WILL BE COATED WITH MIL-C-16173 PRIOR TO BUSHING INSTALLATION AND FACE OF LUG WILL BE COATED WITH MIL-PRF-81733 PER PARAGRAPH G.

PREPARED BY CAROL HYER	SYMBOL LGMPM	DATE 21 Aug 02
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REV:	ENGINEERING DATA REQUIREMENTS CONTINUATION SHEET (ATTACHMENT "A")	
PART NUMBER 200210077-10	NATIONAL STOCK NUMBER 1620-01-157-0020LE	
<p>17. APPLY FILLET SEAL USING MIL-PRF-81733 IN LIEU OF BMS 5-95 PER D3-1453.</p> <p>18. FINISH F-1.10, APPLY ONE COAT CORROSION PREVENTIVE COMPOUND PER MIL-C-81309, TYPE II, CLASS OPTIONAL.</p> <p>19. FOR FINISH F-4.20, CADMIUM PLATE PER SAE AMS-QQ-P-416, TYPE II, CLASS 2.</p> <p>20. FOR FINISH F-1.76, CAD TITANIUM PLATE PER MIL-STD-1500, TYPE II, CLASS 1.</p> <p>21. FOR FINISH F-1.846, CHROME PLATE PER MIL-STD-1501, TYPE II, CLASS 2.</p> <p>22. FOR FINISH F-12.37, APPLY TWO COATS EPOXY WATERBORNE PRIMER PER MIL-PRF-85582, TYPE I, CLASS 2. ALTERNATE TWO COATS EPOXY-POLYAMIDE PRIMER PER MIL-PRF-23377, TYPE I, TO DRY FILM THICKNESS OF 0.0006 INCH MINIMUM.</p> <p>23. FOR FINISH F-12.37 PLUS F-12.6589, APPLY ONE COAT EPOXY WATERBORNE PRIMER PER MIL-PRF-85582, TYPE I, CLASS 2. ALTERNATE ONE COAT OF EPOXY POLYAMIDE PRIMER PER MIL-PRF-23377, TYPE I, FOLLOW WITH TWO TOPCOATS POLYURETHANE PER MIL-PRF-85285, TYPE I, COLOR NUMBER 17925 (WHITE) PER FED-STD-595, IN LIEU OF MIL-C-83286, WHICH HAS BEEN CANCELLED.</p> <p>24. THE FORGINGS SHALL BE PROCURED FROM THE ORIGINAL FORGING SOURCE, USING THE ORIGINAL CERTIFIED FORGING PROCEDURES AND DIES/TOOLING.</p> <p>A. PRIOR TO CONTRACT AWARD, THE DETAIL PART BIDDER SHALL PROVIDE CERTIFICATION, FROM THE FORGING SOURCE, TO THE GOVERNMENT THAT THE CERTIFIED DIES AND PROCEDURES ARE AVAILABLE AND THE FORGING SOURCE HAS AN AGREEMENT WITH THE DETAIL PART BIDDER TO PROVIDE FORGINGS FOR THEIR USE IN THE EVENT THEY ARE THE SUCCESSFUL BIDDER.</p> <p>B. PRIOR TO PRODUCTION, FORGING LOT QUALIFICATION SHALL BE ACCOMPLISHED AS SPECIFIED ON THE FORGING DRAWING AND SAE AMS-F-7190, GRADE A FOR STEEL FORGINGS AND SAE AMS-A-22771 FOR ALUMINUM FORGINGS. THE DETAILED PART CONTRACTOR SHALL ASSURE THAT THIS HAS BEEN ACCOMPLISHED BY THE FORGING SOURCE AND SHALL SUBMIT CERTIFIED DOCUMENTATION OF ACCOMPLISHMENT TO THE GOVERNMENT.</p> <p style="text-align: center; font-size: 48px; font-weight: bold;">G P L R</p>		
PREPARED BY CAROL HYER	SYMBOL LGMPM	DATE 21 Aug 02

REV:	ENGINEERING DATA REQUIREMENTS CONTINUATION SHEET (ATTACHMENT "A")	
PART NUMBER  200210077-10	NATIONAL STOCK NUMBER  1620-01-157-0020LE	

G P L R

25. FORGING SOURCE, CONTROL AND LOCATION OF DIES:

A. FORGING DRAWING: 458-56149-1  
DIE NUMBER: 6372

B. CONTROL OF FORGING PROCESS: HEROUX INC  
755 THURBER AVE  
LONGUEIL PQ CANADA  
J4H 3N2

C. LOCATION OF FORGING: CANTON DROP FORGE  
4575 SOUTHWAY STREET, S.W.  
PO BOX 6902  
CANTON, OHIO 44706-0902

26. ALL QUALIFICATION TEST REPORTS AND ACTUAL FORGING MACRO SECTIONS (SEALED WITH CLEAR LACQUER) WILL BE RETAINED FOR GOVERNMENT REVIEW IN LIEU OF BOEING ENGINEERING REVIEW.

27. D2-5000, BAC 5005, BAC 5009, BAC 5300, BAC 5601, BAC 5602, BAC 5004, BAC 5440, BAC 5435, BAC 5727, BACD 2097, D3-1453, D3-6002, 458-1026, F-12.101 AND F-12.108 ARE NOT REQUIRED FOR MANUFACTURE.

28. USE MATERIAL SAE AMS 4590 IN LIEU OF AMS 4590.

29. USE MATERIAL SAE AMS 4881 IN LIEU OF AMS 4881.

30. PER DRAWING 30-3110 USE MATERIAL SAE AMS 4640 IN LIEU OF AMS 4640.

31. USE MATERIAL SAE AMS 4535 IN LIEU OF AMS 4535.

32. PER DRAWING 30-3110 HEAT TREAT TO DWG REQUIREMENTS PER SAE AMS-H-6088 IN LIEU OF MIL-H-6088 AND BAC 5602.

33. OO-ALC/LILE SYSTEM ENGINEERING RETAINS ALL RIGHTS TO REVIEW AND ACCEPT MATERIAL REVIEW BOARD (MRB'S) DISPOSITIONS PRIOR TO SHIPMENT OF DISCREPANT ITEM. ALL DEVIATIONS MINOR AND MAJOR, FROM THE ENGINEERING DRAWING PACKAGE SHALL BE SUBMITTED FOR MRB DISPOSITION.

34. PRIOR TO CONTRACT AWARD, THE CONTRACTOR SHALL CERTIFY TO THE GOVERNMENT IN WRITING FULL COMPLIANCE WITH MANUALS, SPECIFICATIONS, AND STANDARDS CALLED OUT AND REQUIRED FOR THE MANUFACTURE OF THIS CONTRACTED LANDING GEAR COMPONENT/ASSEMBLY. CONTRACTOR IS RESPONSIBLE TO COMPLETELY SEARCH THESE MANUALS, SPECIFICATIONS, AND STANDARDS AND FULLY UNDERSTAND THE REQUIREMENTS NECESSARY TO MANUFACTURE LANDING GEAR COMPONENTS. ANY QUESTIONS CAN BE FORWARDED TO OO-ALC/LILE.

35. AFTER CONTRACT AWARD, THE SUCCESSFUL BIDDER SHALL PROVIDE A COPY OF THE PROCESSING DOCUMENTATION (ROUTING DOCUMENTS AND PROCESS SPECIFICATIONS) TO LILE FOR FINAL REVIEW BEFORE PRODUCTION BEGINS.

PREPARED BY  CAROL HYER	SYMBOL  LGMPM	DATE  21 Aug 02
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**SOURCE QUALIFICATION REQUIREMENTS**  
(PL98-525, SECTION 2319)

STOCK NR (NSN)1620-01-157-0020LE  
NOUN: Piston, Landing Gear

PART NUMBER (P/N)200210077-10  
AIRCRAFT:KC-135R

**SECTION C**

**QUALIFICATION REQUIREMENTS THAT MUST BE SATISFIED TO BECOME A QUALIFIED SOURCE:**

1. Because of the need for uninterrupted item support to military aircraft systems while keeping with the requirements of PL 98-525, the current acquisition need not and generally will not be delayed to provide an offeror an opportunity to qualify. Normal acquisition practices at OO-ALC should preclude the denial of opportunity to any interested offeror.
2. The offeror must provide a pre-contract award qualification article, which meets the requirements of the engineering drawings, material specifications, and process specifications. However, successful completion of the qualification testing does not guarantee any contract award. If the offeror is deemed qualified and awarded the contract, a post-contract award first article exhibit may be required to verify production capability.
3. The qualification article will be subjected to form, fit, and function verification as well as required testing to assure compliance with data list and other applicable procurement criteria. The qualification article shall demonstrate full compatibility and comparability with existing parts.
4. The required materials will be procured from a qualified source and shall meet the requirements of their respective specifications. The offeror will assure that the supplier has accomplished this and shall submit certified documentation of accomplishment of the above requirements to the purchaser along with the pre-contract award qualification article.
5. The required materials will be procured from a qualified source and will meet the requirements of their respective specifications. The offeror will assure that the material supplier has accomplished this and will submit certified documentation of accomplishment of the above requirements to the purchaser along with the pre-contract award qualification article. Also, the required forging will be procured from the qualified forging source using the original certified forging procedures and dies. Forging material and lot qualification will be accomplished as required in the specified forging drawing, P/N 458-56149-1 and specification SAE AMS-F-7190. The offeror will assure that this is or has been accomplished by the forging source and will submit certified documentation of accomplishment of the above requirements to the government along with the pre-contract award qualification article.
6. The qualification article once submitted will become subject to such testing as deemed necessary by the U.S. Government to prove that the article meets all dimensional, processing and functional requirements. Such testing may result in the destruction of the article. Following completion of necessary testing and evaluation, the article no matter what its condition shall be returned to the contractor or disposed of at his discretion and direction whether it was found acceptable or not.
7. Form verification: The U.S. Government's Quality Verification Center (QVC) will be used to insure compliance with the dimensional requirements of the article. Material and processing compliance will also be verified as required.
8. Fit/function verification: Existing components and government test stands and fixtures will be utilized to verify physical interface and functional performance of articles.
9. Testing for material and process compliance.
  - (a) Material analysis
  - (b) Heat treat
  - (c) Grinding
  - (d) Plating
  - (e) Finish
  - (f) Grain flow
  - (g) Other

**SOURCE QUALIFICATION REQUIREMENTS**  
(PL98-525, SECTION 2319)

STOCK NR (NSN) 1620-01-157-0020 / E  
NOUN: Piston, Landing Gear

PART NUMBER (P/N) 200210077-10  
AIRCRAFT: KC-135R

10. Remarks:

- a. Organic verification capabilities exist at OO-ALC.
- b. Testing requirements outside organic capabilities will be contracted out.

11. The estimated cost of government testing and evaluation is \$5000.00.

12. Maximum time for testing of the qualification article will not exceed 30 days from receipt at testing agency.

**SECTION D**

**QUALIFICATION WAIVER REQUIREMENTS.**

1. An offerer who has had previous experience in the manufacture and qualification of items, which can be correlated with this product, may apply to the design control authority at OO-ALC for a waiver of the above stated qualification requirements.

- a. The qualification waiver criteria utilized by the design control authority to perform a qualification analysis are available upon request. The qualification waiver criteria may be used as a guide in preparing the offerer's written input to the design control authority.

- b. The burden of proof for written inputs is on the offerer. The design control authority will not pursue authenticity verification of claims made by the offerer of product manufacturing experience with other Government or non-Government agencies. Unsubstantiated claims will not be considered in the waiver analysis process.

- c. This waiver will be granted if and only if the design control authority (LGHLEN) can establish the qualifications of the offerer through the evaluation of written inputs from the offerer or from previous knowledge of the offerer's capabilities or from previous experience with the offerer on similar item acquisitions. If there is any doubt about the offerer's capability, the offerer will be required to submit a pre-qualification article. There is no guarantee of qualification by similarity. LGHLEN reserves the right to require a pre-qualification article of all offerers.

2. The current acquisition need not and will not be delayed in order to provide an offerer with an opportunity to meet the requirements for qualification waiver.

3. Maximum time for approval of qualification by similarity will not exceed 15 days.

<b>SPECIAL PACKAGING INSTRUCTION</b>				CODE ID 98747	SPI NO. ( TPO ) 01-157-0020																																																																
PART OR DRAWING NO. 458-56119-1		NATIONAL STOCK NO. 1620-01-157-0020	CURRENT REV	ILL E. NYE																																																																	
ITEM NOMENCLATURE MAIN CYLINDER, INNER OLEO, KC-135			ORIGINAL DATE 86344	CHK N. WALLWORK ENGR F. LANDERS AUTH B. EVANS																																																																	
<b>PRESERVATION</b> IAW MIL-P-116 LEVEL A METHOD I LEVEL B METHOD I LEVEL C METHOD I QUP 1 EA ICQ N/A CLEANING C-5 DRYING D-4 PRESERVATIVE MIL-C-16173, GR 2 (OR EQUAL) <b>MARKING</b> IAW MIL-STD-129 SPECIAL MARKINGS: A) SPI NO. 01-157-0020 MARK THE SPI NUMBER ON ONE SIDE OF THE CONTAINER AND ON ALL REMOVABLE DUNNAGE.			<b>PACKING</b> AS SPECIFIED BELOW AND BILL OF MATERIALS <table style="width: 100%; border-collapse: collapse;"> <thead> <tr> <th style="text-align: left;">LEVEL</th> <th style="text-align: left;">SPEC</th> <th style="text-align: left;">STYLE</th> <th style="text-align: left;">TYPE</th> <th style="text-align: left;">CL</th> <th style="text-align: left;">VRTY</th> <th style="text-align: left;">GR</th> </tr> </thead> <tbody> <tr> <td>A</td> <td>MIL-B-26195(MOD)</td> <td>A</td> <td>II</td> <td>1</td> <td></td> <td></td> </tr> <tr> <td>B</td> <td>MIL-B-26195(MOD)</td> <td>A</td> <td>I</td> <td>1</td> <td></td> <td></td> </tr> <tr> <td>C</td> <td>MIL-B-26195(MOD)</td> <td>A</td> <td>I</td> <td>1</td> <td></td> <td></td> </tr> </tbody> </table> <table style="width: 100%; border-collapse: collapse;"> <thead> <tr> <th></th> <th style="text-align: left;">LEVEL A</th> <th style="text-align: left;">LEVEL B</th> <th style="text-align: left;">LEVEL C</th> </tr> </thead> <tbody> <tr> <td>GROSS CU FT</td> <td>25.951</td> <td>25.951</td> <td>25.951</td> </tr> <tr> <td>GROSS WT LBS</td> <td>290</td> <td>290</td> <td>289</td> </tr> <tr> <td>DESIGN FRAGILITY</td> <td>G 110</td> <td>110</td> <td>110</td> </tr> </tbody> </table> <table style="width: 100%; border-collapse: collapse;"> <thead> <tr> <th></th> <th style="text-align: left;">LENGTH</th> <th style="text-align: left;">WIDTH</th> <th style="text-align: left;">DEPTH</th> </tr> </thead> <tbody> <tr> <td>CNTNR I.D.</td> <td>72</td> <td>22</td> <td>20</td> </tr> <tr> <td>CNTNR O.D.</td> <td>74</td> <td>24</td> <td>25 1/4</td> </tr> <tr> <td>ITEM DIM</td> <td>69</td> <td>13 3/4</td> <td>14 1/2</td> </tr> <tr> <td>ITEM WT LBS</td> <td>205</td> <td></td> <td></td> </tr> </tbody> </table>			LEVEL	SPEC	STYLE	TYPE	CL	VRTY	GR	A	MIL-B-26195(MOD)	A	II	1			B	MIL-B-26195(MOD)	A	I	1			C	MIL-B-26195(MOD)	A	I	1				LEVEL A	LEVEL B	LEVEL C	GROSS CU FT	25.951	25.951	25.951	GROSS WT LBS	290	290	289	DESIGN FRAGILITY	G 110	110	110		LENGTH	WIDTH	DEPTH	CNTNR I.D.	72	22	20	CNTNR O.D.	74	24	25 1/4	ITEM DIM	69	13 3/4	14 1/2	ITEM WT LBS	205		
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**CLOSURE** IN ACCORDANCE WITH MIL-B-26195

**NOTES**

1. SURFACES COATED WITH PRESERVATIVE SHALL BE WRAPPED WITH MIL-B-121, TYPE II, GR A, CLASS 2.
2. CUT SADDLE SUPPORTS, -4, TO SAME LENGTH AND WIDTH AS SADDLES, -5 & -6.
  - A. ATTACH ONE SUPPORT, -4, TO EACH SIDE OF EACH SADDLE BEFORE CUTTING SADDLE PATTERN.
  - B. SECURE SUPPORTS TO SADDLE WITH 4d NAILS CONFORMING TO FF-N-105, TYPE II, STYLE 7.

PART NO.	QTY REQD	NOMENCLATURE OR DESCRIPTION	SIZE (INCHES UNLESS SPECIFIED)	MATERIAL SPECIFICATION
-14	8	NUTS	3/8	FF-N-836 TYPE II, STYLE 4
-13	20	LAG BOLTS	1/4 DIA X 2 1/2	FF-B-561 TYPE I, STYLE 1, GR B
-12	30	WASHERS	1/4	FF-W-92 TYPE A, GR I, CLASS A
-11	10	WASHERS	3/8	FF-W-92 TYPE A, GR I, CLASS A
-10	4	BOLTS	3/8 DIA X 9	FF-B-584 TYPE I, CLASS 1, STYLE A
-9	6	HEADER BOLTS	3/8 DIA X 7	FF-B-584 TYPE I, CLASS 1, STYLE A
-8	2	HOLD DOWN STRAPS	23 X 1 1/4 X .035	QQ-S-781 CL 1, TYPE I, HVY DUTY, FIN A
-7	2	CHAFFING STRIPS	34 X 3 1/2 X 1/8	PPP-P-115 TYPE I
-6	1	REAR SADDLE	2 X 8(NOM) X 22	MIL-STD-731 CLASS 2
-5	1	FRONT SADDLE	2 X 8(NOM) X 22	MIL-STD-731 CLASS 2
-4	4	SADDLE SUPPORTS	5/16 THICK (SEE NOTE 2)	NN-P-530 GROUP B
-3	1	BASE	72 X 22 X 3/4	NN-P-530 GROUP B
-2	2	HEADERS	2 X 2(NOM) X 72	MIL-STD-731 CLASS 2
1	3	SKIDS	4 X 4(NOM) X 24	MIL-STD-731 CLASS 2

# SPECIAL PACKAGING INSTRUCTION

CODE ID

98747

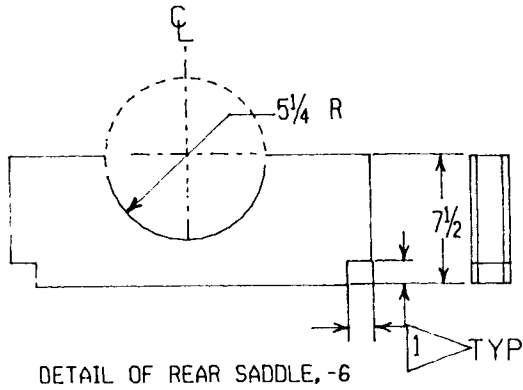
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01-157-0020

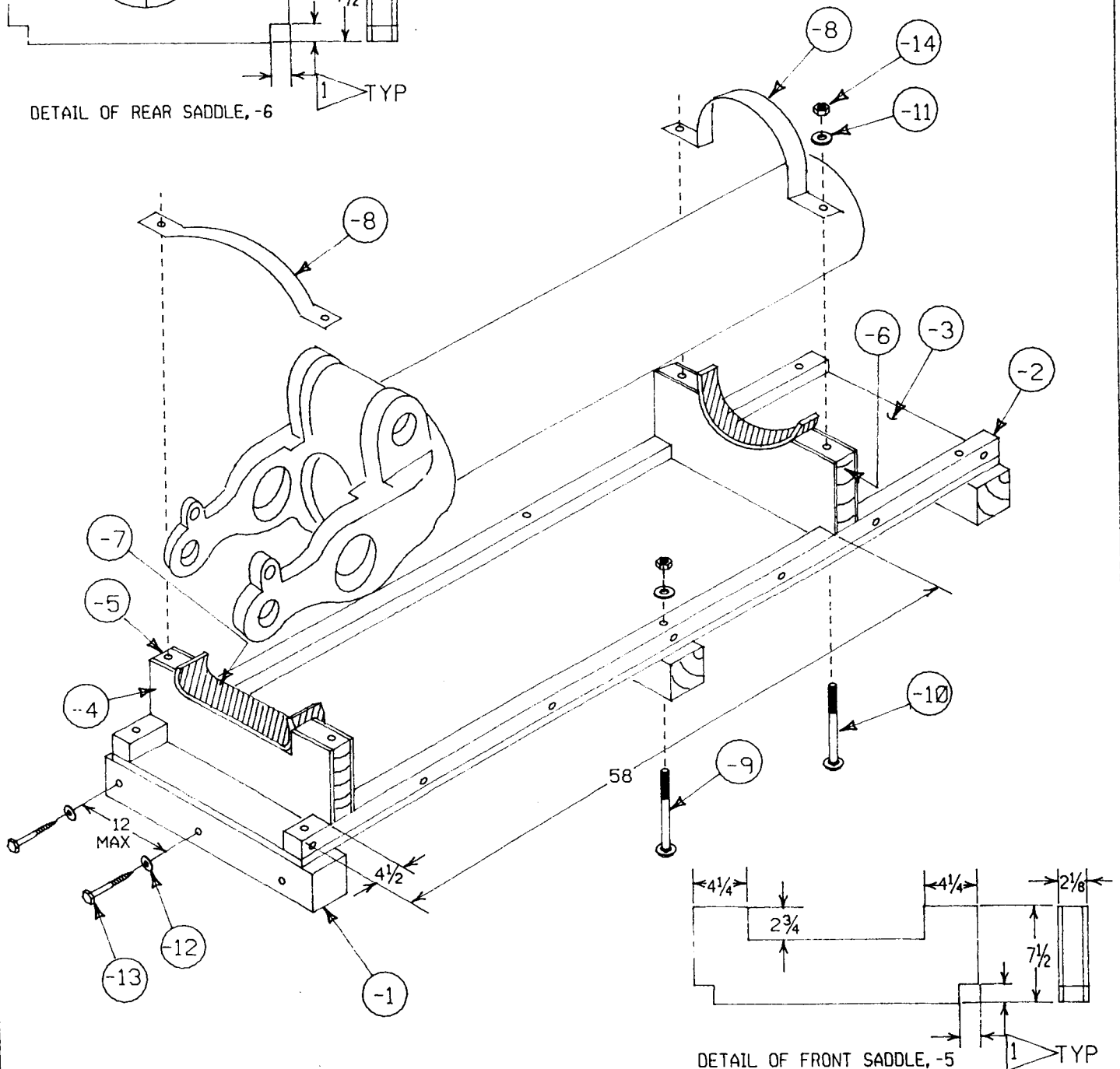
## ITEM NOMENCLATURE

MAIN CYLINDER, INNER OLEO, KC-135

SHEET 2 OF 2



1 CUTOUT OF SADDLES WILL BE DEPENDENT ON ACTUAL SIZE OF HEADER, -2.



**CERTIFICATION REGARDING THE USE OF RIGHTS GUARD TECHNICAL DATA**

- a. The bidder/offeror certifies that he will observe the following data disclosure and use restrictions on all data claimed to be proprietary to the Boeing Company (hereafter called "Rights Guard Technical Data"):
1. Rights Guard Technical Data shall not be reproduced, in whole or in part, except as required to respond to the Rights Guard Solicitation, or to perform any resulting Rights Guard Contract.
  2. Rights Guard Technical Data shall not be incorporated, in whole or in part, into other documentation, nor shall it be otherwise utilized except as required to respond to the Rights Guard Contract.
  3. Rights Guard Technical Data shall not be disclosed, in whole or in part, to any other person or entity and shall be disclosed within bidder's/offeror's company only to those employees having a need to know for the purpose of responding to the Rights Guard Solicitation or performing any resulting Rights Guard Contract.
  4. Rights Guard Technical Data will be returned or destroyed by all unsuccessful bidders/offerors promptly upon the award of a contract, and by each contractor promptly upon completion of contract performance. Mylars are not to be returned, but certification that they have been destroyed will be furnished. Simultaneously with the return or destruction of all such data, the respective bidder/offeror/contractor shall provide to the government a certification that all Rights Guard Technical Data has been returned or destroyed, as appropriate. This certification shall contain complete listing by drawing number or document number of the data destroyed. Failure to take such actions shall be grounds for removal of the bidder/offeror/contractor from qualifying bidders lists for all Rights Guard Procurements.
- b. CAUTION: The Government will notify The Boeing Company of an actual or suspected breach of the restrictions set forth in this certificate which may come within its knowledge. A violation of such restrictions may be grounds for legal proceedings against the violators by the Government and/or by The Boeing Company.
- c. Rights Guard Certifications shall be made a part of the Government's contract file to which the certification pertains. This file and any related documentation shall be made available to The Boeing Company upon request.

\_\_\_\_\_  
Company Name, Address & Mfg Code

\_\_\_\_\_  
Signature

\_\_\_\_\_  
Typed Name

\_\_\_\_\_  
Date

NOTE #1      Rights Guard Certifications that contain alterations deletions or additions will not be accepted, and no Rights Guard Technical Data will be transmitted to any bidder/offeror until an unaltered, properly executed Rights Guard Certification has been received by the Government.

NOTE #2      Any previous unmarked KC-135R Data previously furnished by the U.S. Air Force and not having the "Boeings Proprietary Rights Legend" on it will be marked with the following legend before use of such data:

# Government Purpose License Legend

Contract No.      Settlement Agreement in CL. ct. No. 309-89C

Contractor:      The Boeing Company

Government Purpose License Rights shall be effective until otherwise mutually agreed by the government and Boeing.

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